

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002939**Date Inspected:** 06-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 830**Contractor:** Japan Steel Works, Ltd.**Location:** Muroran, Japan**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date OSM Quality Assurance (QA) Representative Daniel L. Reyes observed the repair welding on the saddle casting scheduled on this date. The following was observed:

Foundry Shop

At the start of the shift the QA inspector traveled to the Foundry Shop to observe the repair welding on the casting ribs scheduled on this date. The welding was performed utilizing the Shielded Metal Arc Welding (SMAW) process and the Alternate Current (AC) electrical power source as per the Welding Procedure Specification (WPS) SJ-3026-2. The welding was performed by Japan Steel Works, Ltd. (JSW) welding personnel, Kazuya-Komai ID 06-2008 which was conducted on the West Deviation Saddle identified as W2E1 which was performed in the horizontal (2G) position with the work in the vertical plane and the axis of the weld horizontal. The consumable appeared to be identified as LB-106, a product of Hobart Brothers and appeared to comply with the AWS Specification A5.5 and the AWS Classification E10016-G.

At approximately 22:45 hours the welder completed the repair welding on the rib 2L. Shortly thereafter, the welder relocated to the casting rib identified as 3L and at approximately 23:30 hours the welder commenced the repair welding on the areas identified as 3-4 and 3-5.

The QA inspector verified the preheat temperatures of 203 degrees Celsius. At the conclusion of verifying the preheat temperatures the QA inspector performed the verification of the AC welding parameters which were observed as follows, 210 amps and 24.3 volts with a travel speed measured at 151.2 Millimeters Per Minute (MM/M).

The QA inspector observed and verified the preheat temperatures, interpass temperatures and the welding parameters at random intervals during this shift. The QA inspector utilized the WPS as a reference during the

WELDING INSPECTION REPORT

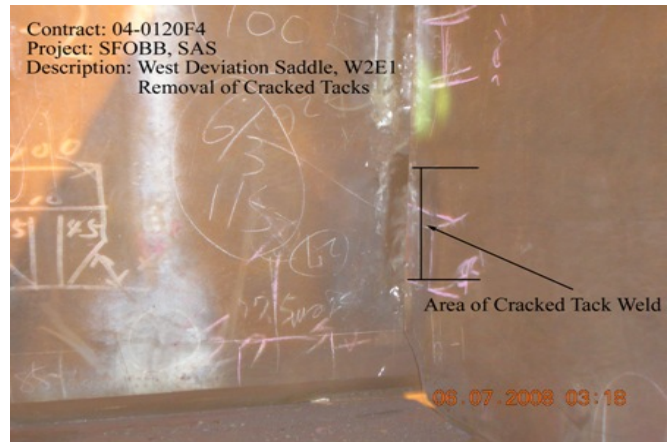
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verification process.

Fabrication Shop # 4

At approximately 02:00 hours the QA inspector traveled to the fabrication shop and observed one (1) JSW personnel performing the grinding task on the West Deviation Saddle identified as W2E1. It appeared the grinding was performed on the stem plate to base plate and the rib plate to stem plate connections to remove the existing cracks on the multi-pass tack welds. The removal of the cracked tack welds was not completed during this shift on this date.

The following digital photograph illustrate the observations of the activities performed on this date.



Summary of Conversations:

There were no general conversations relative to this project on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
